

# Work Order ID 60192

Monday, June 28, 2010 3:18:46 PM



Page 1

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 6/28/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 40.00

Customer:

Reference:

Approvals:

Process Plan:

*PP*

Date: *10/6/29* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3537	Rev C

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☒ Dwg Rev: *C* ☐ Prog Rev: *C* ☐ 2-Deburr if necessary

*304.063*

*Deburr => m/l w/06/30*

*RB 10-6-30*

*(48)*

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

*RB 10-6-30*

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

*can'to*  
*(48)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3537-1

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Revision ID:

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Start Date: 6/28/2010 Start Qty: 40.00

Required Date: 7/5/2010 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

SB 6/27/05

48

140

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat  
M 114518 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary

10-8-4  
E2 10-8-4

48

150

0.00



QC

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Quality Control

S. W. 8/04

count  
48

W/O:		WORK ORDER CHANGES						
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# Work Order ID 60192

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Item ID: D3537-1

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Setup Start

Revision ID:

Stop

Item Name: Wearpad

Start Date: 6/28/2010 Start Qty: 40.00

Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:00 ☐ OVEN TEMPERATURE:  
320° ☐ FINISH TIME: 11:30

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*Handwritten:* 8/10/08/04  
*Handwritten:* XYS  
*Handwritten:* Location

*Handwritten:* 48 BR 10-8-5.

*Handwritten:* ml 10 08 05 (48)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 60192**

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Item ID: D3537-1

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Setup Start

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Item Name: Wearpad

Start Date: 6/28/2010 Start Qty: 40.00

Required Date: 7/5/2010 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg &amp; Stock Location

0.00



Packaging

Memo

0.00

Packaging

48 BP 108-4

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/05  
MF  
10-8-05

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**NOTE:** Date & initial all entries



# Picklist Print

Monday, June 28, 2010 3:18:53 PM

Page 1

Work Order ID: 60192

Parent Item: D3537-1

Parent Item Name: Wearpad





Start Date: 6/28/2010

Required Date: 7/5/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	77.3439	0.106	4.463158	5.8		
304/316 Sheet .063											(B10-6-30)		

Location

Loc Qty

Loc Code

MAT

77.34389474

111323

0

114799

77.3438947

114799

(48)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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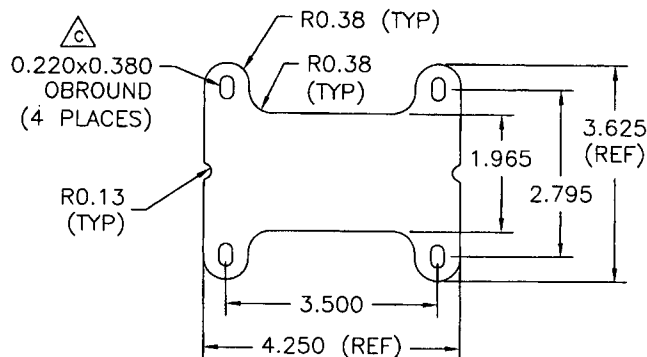
SHOP  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

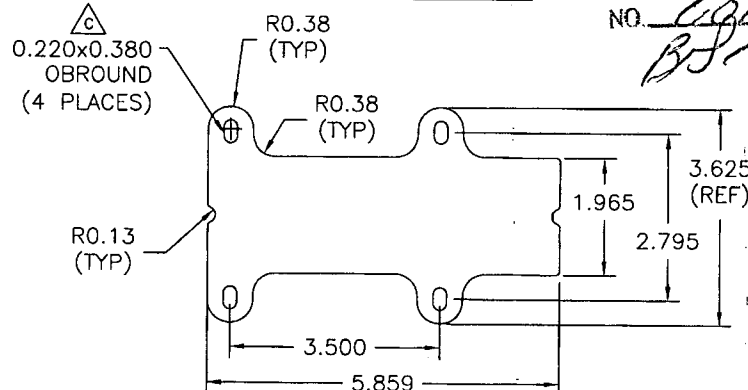
WITHOUT NOTICE  
WORK ORDER

NO. *69192*  
*BS10-6-29*

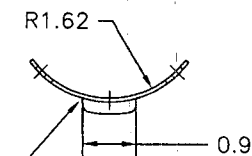
**D3537-1F FLAT PATTERN**



**D3537-3F FLAT PATTERN**

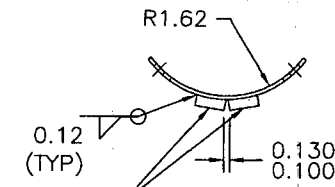


**SECTION A-A**



APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

**SECTION B-B**

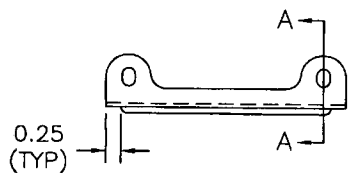


D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

**RELEASED**  
07.05.08 PH  
REV ELN 962

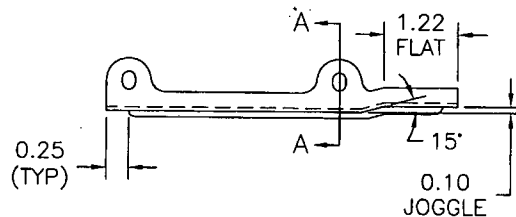
**D3537-1 LONGITUDINAL BEND**

(MADE FROM D3537-1F)



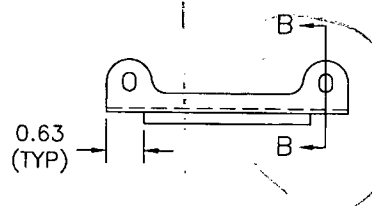
**D3537-3 LONGITUDINAL BEND**

(MADE FROM D3537-3F)



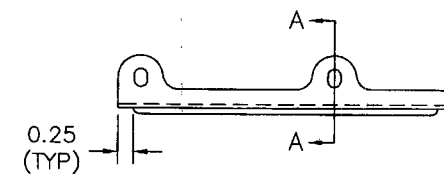
**D3537-5 LONGITUDINAL BEND**

(MADE FROM D3537-1F)



**D3537-7 LONGITUDINAL BEND**

(MADE FROM D3537-3F)



**D3537-1/-3/-5/-7 WEARPAD NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	A	APPROVED A
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
SHEET 1 OF 1		SCALE
		1:2

**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, MA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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